

Date: Tuesday, 02/06/2009 11:29:38 AM
 User: Julie Dawson

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 350 BASKET LID (SHORT) |
| Job Number : 48310B | |
| Estimate Number : 10210 | |
| P.O. Number : | Part Number : D3266041 |
| This Issue : 02/06/2009 S.O. No. : | Drawing Number : D3266 REVB |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : // Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 47269B | Material : |
| Written By : | Due Date : 10/06/2009 Qty: 1 Um: Each |
| Checked & Approved By : <u>JUL 09.06.02</u> | |
| Comment : Est Rev:B Re-Format 05-11-03 JLM Est Rev:C 08-09-10 revB as per dwg (ecn 08-524) DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-------|--------|-------------|
| ✓ 1.0 | D31663 | Basket Hoop |
|-------|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty 1 D3166-3 Basket Hoop Batch: B47957SAN 09-06-17

| | | |
|-------|----------------|---------------------------|
| ✓ 2.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W |
|-------|----------------|---------------------------|

End Bar Scrap = 2 st

Comment: Qty.: 28.3500 f(s)/Unit Total : 28.3500 f(s)

3/4" x 3/4" square tubing 304/316 SS tube .065" wall

B# m111885

(M304TS0.750W.065)

Batch: M112051 (22.6) M111885 (5.75)SAN 09-06-17 ①

| | | |
|-------|--------|--------------|
| ✓ 3.0 | D22321 | Basket Hinge |
|-------|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B48230pl09-06-22

| | | |
|-------|--------|----------------|
| ✓ 4.0 | D23271 | Spacer Bushing |
|-------|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

346325pl09-06-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET LID (SHORT)

Job Number: 48310B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓

5.0

D2506

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

B45735

Pl 09-06-22

✓

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B476264

Pl 09-06-22

✓

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 10.0000 sf(s)/Unit Total : 10.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

10sf M304EX0.75-16F

Expanded Metal

M111956

SAD 09-06-18 (1)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236 From D3166-3

SAD 09-06-18

6

2-Cut 3/4" x 3/4" square tubing as per Dwg D3266

SAD 09-06-18

(1)

3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305

SAD 09-06-18

(1)

4-Deburr & Remove all markings from material

SAD 09-06-18

(1)

5-Weld as per Dwg D3266 using Welding Table and corner Jig Deburr as required

Pl 09-06-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 48310B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.23

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 02/06/23 (K)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

10:00am

OVEN TEMPERATURE:

400°F

FINISH TIME:

10:30am

2ND COAT:

START TIME:

10:45am

OVEN TEMPERATURE:

400°F

FINISH TIME:

11:15am

sh 09-06-23 (K)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Batch: M111013

and Spray Paint black Batch: M110907

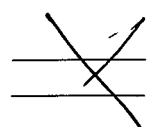
as per Dwg D3266 and QSI 005 4.4

A.n 09.06.23 (L)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:



13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

PK 09-06-24 P.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: 350 BASKET LID (SHORT)

Job Number: 48310B

Part Number: D3266041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/24 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U Sp. 06.24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|-------------|------------------|
| X | D3266-041 | BASKET ASSEMBLY |
| 2 | D2232-1 | HINGE PLATE |
| 4 | D2236 | RIB |
| 2 | D2327-1 | BUSHING |
| 1 | D2506 | LABEL PLATE |
| 2 | D2581 | MOUNTING BRACKET |
| 2 | D3266-1 | RIB |
| 2 | D3266-3 | RIB |
| 6 | D3266-5 | RIB |
| 3 | D3266-7 | RIB |

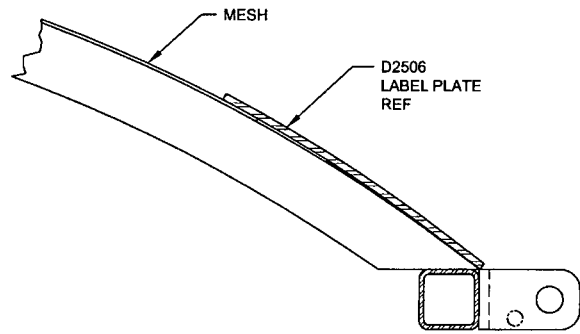
RELEASED
08-29-04/14

- NOTES:**
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
 - 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: N/A
 - 9) WELD PER DART QSI 004

| | | | |
|------------|--|--|--------------|
| B | INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK. | AJS | 08.08.15 |
| A | NEW ISSUE | CP | 04.02.02 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | DRAWING NO. | REV. B |
| CHECKED | PH | D3266 | SHEET 1 OF 5 |
| MFG. APPR. | PH | TITLE | SCALE |
| APPROVED | PH | BASKET LID ASSEMBLY (350) | NTS |
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| DATE | 08.08.15 | | |

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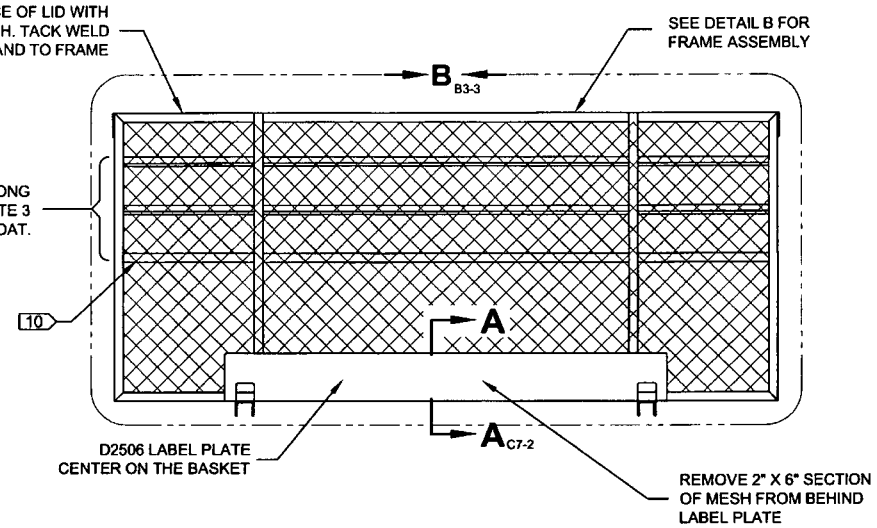
8 7 6 5 4 3 2 1



SECTION A-A
(ROTATED 90° CCW)
SCALE NONE

SKIN OUTSIDE SURFACE OF LID WITH
SS MESH. TACK WELD
EACH END STRAND TO FRAME

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.



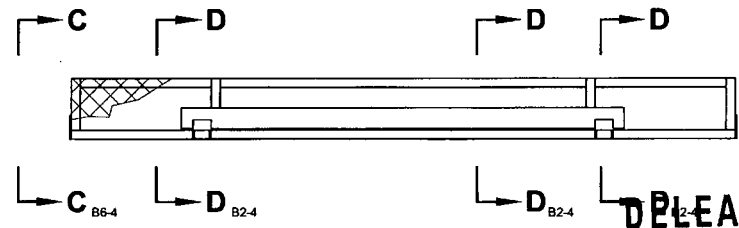
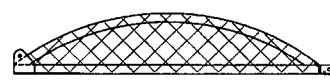
D3266-041 BASKET LID ASSEMBLY

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B

A

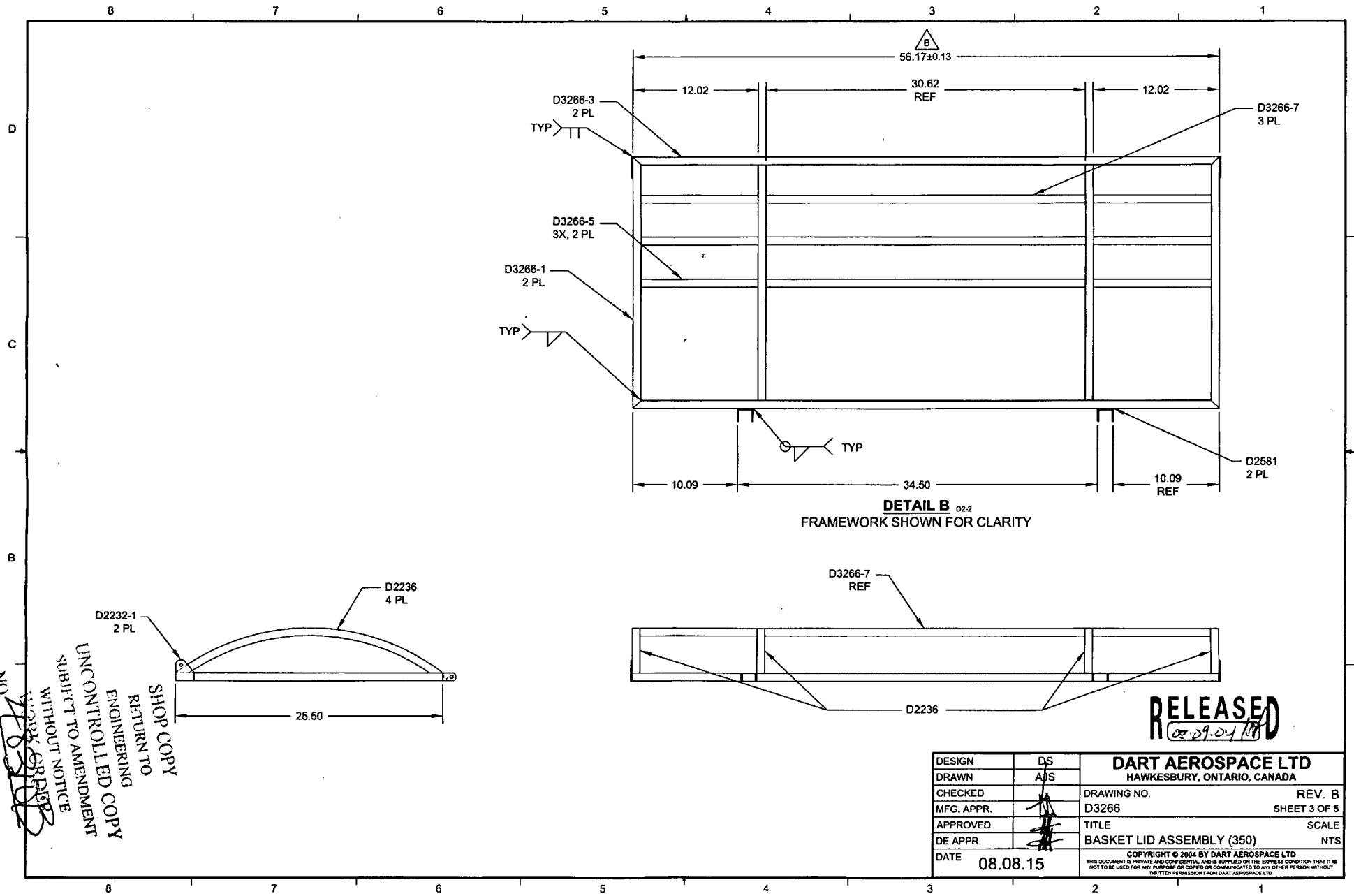
- ASSEMBLY NOTES:**
- 1) MATERIAL: SEE SHEET 1
 - 2) FINISH: FOR OVERALL FINISH SEE SHEET 1
 - 3) FINISH: SPRAY PAINT BLACK INSIDE SURFACE AFTER POWDER COAT
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE
PER DART QSI 005 4.4 AFTER POWDER COAT
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: N/A
 - 9) WELD PER DART QSI 004
 - 10) TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION



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08-07-24/11/12

| | | | |
|------------|----------|---|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3266 | SHEET 2 OF 5 |
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8 7 6 5 4 3 2 1

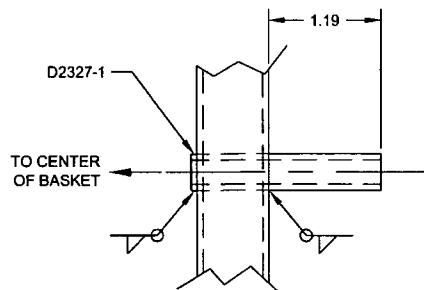


DETAIL B 02-2
FRAMEWORK SHOWN FOR CLARITY

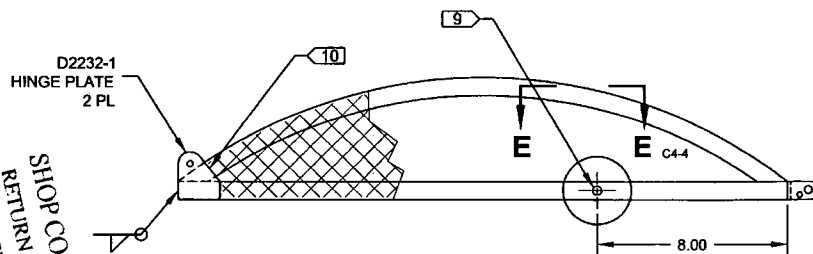
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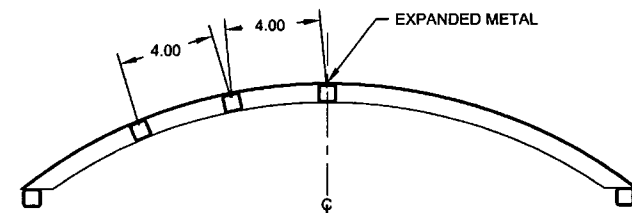
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| DRAWN | AJS | | |
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| MFG. APPR. | | D3266 | SHEET 3 OF 5 |
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VIEW E-E B4-4
SCALE 4X
(BOTH ENDS)



SECTION C-C A4-2
(BOTH ENDS)



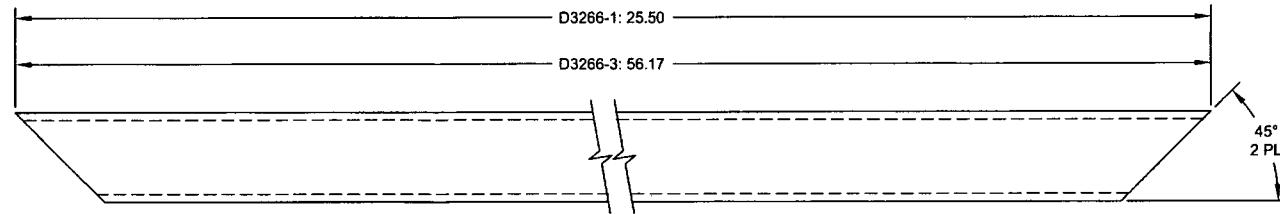
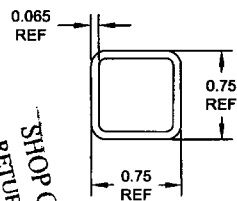
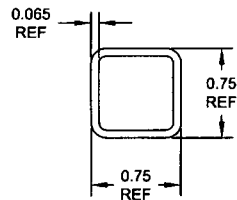
SECTION D-D A1-2
3 PL A2-2
A3-2

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| CHECKED | RL | DRAWING NO. | REV. B |
| MFG. APPR. | | D3266 | SHEET 4 OF 5 |
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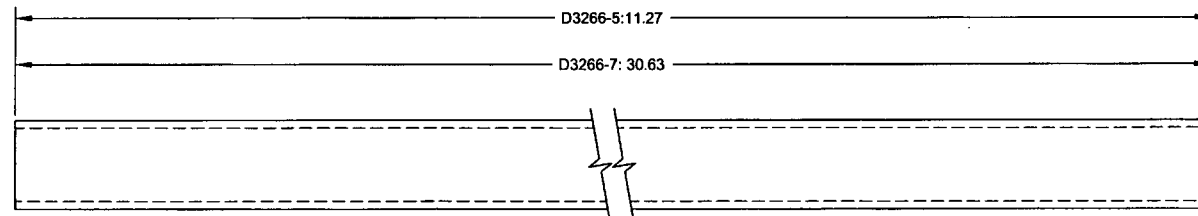
- NOTES:**
- 1) MATERIAL: SEE SHEET 1
 - 2) FINISH: SEE SHEET 1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELD PER DART QSI 004
 - 9) DRILL 3/8 HOLE AND INSTALL D2327-1 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS
 - 10) TRIM MESH AS REQUIRED TO ALLOW D2232-1 HINGE PLATE TO SIT FLUSH ON FRAME

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D3266-1 RIB

D3266-3 RIB



D3266-5 RIB

D3266-7 RIB

RELEASED
08-09-07-17

- RIB NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

| | | | |
|------------|----------|--|--------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | Pat | DRAWING NO. | REV. B |
| MFG. APPR. | 152 | D3266 | SHEET 5 OF 5 |
| APPROVED | 152 | TITLE | SCALE |
| DE APPR. | 152 | BASKET LID ASSEMBLY (350) | NTS |
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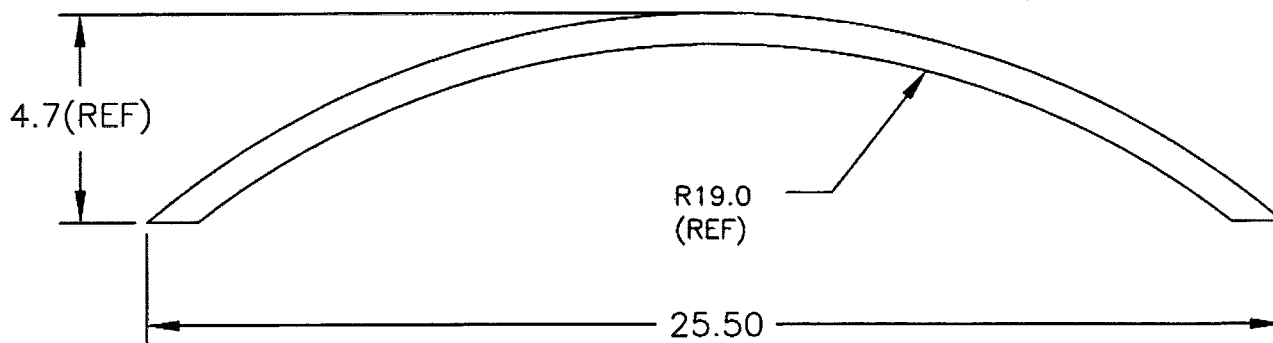
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| DESIGN BW | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2236 | REV. C SHEET 1 OF 1 |
| DATE 05.06.07 | | TITLE LID RIB | SCALE 1:4 |
| A | 94.05.30 | NEW ISSUE | |
| B | 94.12.16 | LID | |
| C | 05.06.07 | UPDATE NOTES, CHANGE RADIUS TO 19.0 | |

RELEASED

05.08.19 #



D2236

D2236 LID RIB

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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